

Work Order ID 126922

Monday, December 01, 2014 11:33:30 AM

126922

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Item ID: D3823-3KGY Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rear Overhead Center (Sub-Component D206-781-161) Grey
 Start Date: 11/27/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/02/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 14-12-01 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
d3823	Rev C

100	0.00								DAS 07 9-09
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100

HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								14/12/08

105	0.00								DAS 07 9-09
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105

HandThermo	Dry Material	0.00							
Hand Finishing Thermoforming	Memo								14/12/08
	Dry Sheet as per QSI022 KYDEX								

Temp: 150 deg. F
 Time IN: 5:00 PM
 Time OUT: 6:00 AM

DEC 07 2014

Per.....

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							DAS 07 9-89
110						x/			
Thermoform	Memo	0.00							
Thermoforming Machine	1-Machine Set-Up								14/12/08
	2-Pre-heat Tool to required temp.								
	3-Thermoform as per Dwg and Folio #FTA031 using tool DT9110								
	Dwg Rev: C								
	Folio Rev: B								
	Visually inspect for proper formation and texture								
140		0.00							DAS 07 9-89
140						x/			
HandThermo	Memo	0.00							14/12/18
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 07 9-89
150						x/			
QC	Memo	0.00							14/12/18
Quality Control	Complete FAI document								

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
160									

QC Memo 0.00

Quality Control

DEC 18 2014

170	Identify as per dwg & Stock Location: _____	0.00
170		
Packaging	Memo	0.00

Packaging

PPD 126914

DAS
06
9-89

DEC 18 2014

180	QC21- Final Inspection - Work Order Release	0.00
180		
QC	Memo	0.00

Quality Control

14/12/18

MF
14-12-18

Picklist Print

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Work Order ID: 126922

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Parent Item: D3823-3KGY

D3823-3KGY

Parent Item Name: Rear Overhead Center (Sub-Component D206-781-161) Grey

Start Date: 11/27/14

Required Date: 12/02/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MKYD6185S.080-P3-52068

Purchased

No

100

sf

3,800.000

10.625

11

MKYD6185S 080-P3-52068

Kydex steel grey (52"x96"-.080)

DAS
07
9-89

Sl
17/12/08

Location

Loc Qty

Loc Code

LAIRD

1180

m129546

347

m129760

347

m130383

486

therm

2620

119476

61

121902

819

122181

1046

m127759

347

m128321

347

11 58 ft.

DART AEROSPACE LTD		Work Order:	126922
Description: Rear Overhead, Center		Part Number:	D3823-3KIV/KGY
Inspection Dwg: D3823	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

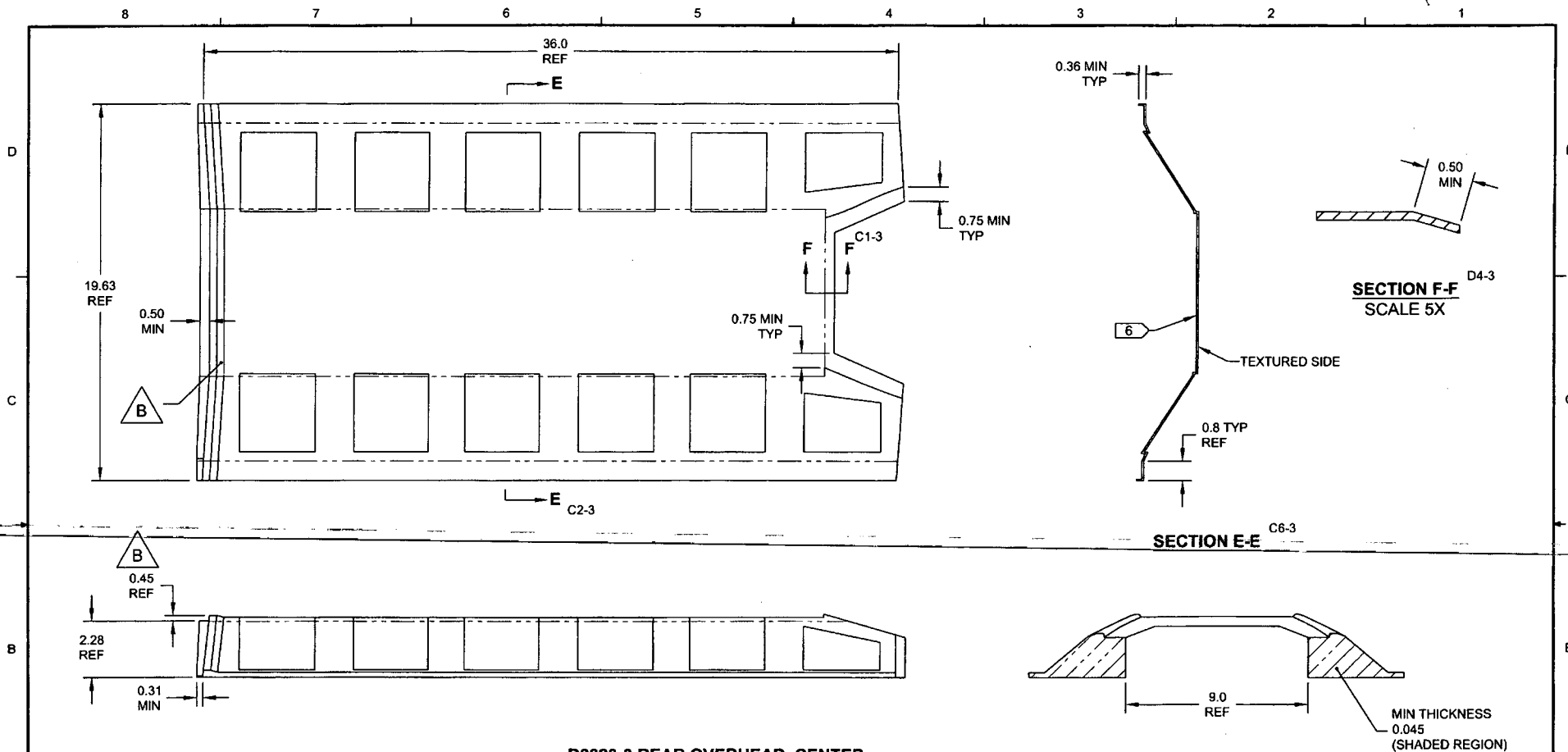
Measured by:	DAS 07 9-89	Date:	14/12/08
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	Min	0.60"	✓			
0.75	Min	0.80"	✓			
0.36	Min	0.41"	✓			
0.50	Min	0.65"	✓			
0.045	Min	0.054"	✓			
0.055	Min	0.069"	✓			

Measured by:	DAS 07 9-89	Date:	14/12/18
Audited by:	DAS 38 9-89	Date:	DEC 18 2014
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ	



D3823-3 REAR OVERHEAD, CENTER

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 2.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9110 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED



PART NUMBER	DESCRIPTION
D3823-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3823-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3823 SHEET 3 OF 3
APPROVED		TITLE SCALE
DE APPR.		REAR OVERHEAD NTS
DATE	09.05.05	

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RELEASED
09/05/05